

4000 Cartridge with 4041 Jig - CRYOTHERM™ HEAT SEALING OVERVIEW

- 1. Cartridge Preparation: (better to prepare *batches* of *hoppers* at one time)**
 - **Remove Mag-Roller and Doctor Blade** (Note: Shutter Arm Cover, Back-plate and Gears do NOT need to be removed.)
 - **Cut the plastic edging** on left-hand side (use diagonal cutters).
 - **Toner Fill Hole – Use one of the following different methods:**
 - **Automatic - Drill new Fill-hole** (use Universal Drill Jig, 4000 Adapter and 7/8" (22mm) bit)
 - **Manual - Drill new Fill-hole** and remove any plastic burrs (use Fill-hole Template, 7/8" (22mm) Fill-hole Cutter and Deburring Tool).
 - **Clean out the hopper**; clean the seal entrance; **clean sealing/gasket area = 4 sides** (use air).
- 2. Place Cartridge into 4041 Insertion Jig**

Swing the Shutter Drum Arm down to the left; it will latch against the hold-down magnet.
- 3. Spread apart the Seal Entrance**
 - **Push the LEFT Jig Handle** all the way forward, until the Left Pin Plate hits the built-in stops.
 - **Push the RIGHT Jig Handle** all the way forward, until the Right Pin Plate hits the built-in stops.
- 4. Insert the Foam Protector**
 - Foam Protector slides on the top of hopper's surface – underneath the foam/tape.
 - Flex the Foam Protector so that the leading edge is angled downwards.
 - **DO NOT just push through unusual resistance.** NOTE: If you still end up pushing out the OEM tape, use long-nose pliers to remove the tape.
- 5. Fold the Seal onto the Insertion Tool + Position Edge of Glue**

It is important to **crease the seal** so that the fold line stays at the tip of the Insertion Tool.
- 6. Slide the Seal into the Cartridge with the Insertion Tool**
 - **Use the Toolaid** to keep the blade of the Insertion Tool flat against the Insertion Jig. Press down on the blade as you slide it forward.
 - When the front of the Insertion Tool handle nears the Pin Plates, **stop and pull back all the way on both Jig handles** – removing the Pin Plates from the cartridge.
 - **Keep the Foam Protector in place until the tool is almost completely inserted** into the cartridge. Continue insertion until the bend in the tool reaches the end of the track on the Jig, then pause and remove the Foam Protector.
 - Due to the thickness of the Insertion Tool handle, **allow the cartridge to rise up in the Insertion Jig** as you near completion.
- 7. Install External Pressure Pads - while hopper is still in Insertion Jig**
 - Install the Far-end Pad (metal) to secure the tip of the Insertion Tool.
 - Install the Insertion-end Pad (plastic) by seal entrance to secure the handle of the Insertion Tool.
 - Install the Large Pad (plastic) to secure the right side of the Insertion Tool.
- 8. Install External Magnet**
 - Raise the shutter-drum arm up and position the Magnet at an angle in the middle cutout.

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9. **Move to Cartridge Holder Jig + Connect Insertion Tool to the Power Supply**
 - **Avoid disturbing the Magnet and Pads** when moving the Cartridge/tool/seal to the Holder Jig.
 - **Use the correct grip** to plug the assembly into the Power Supply (only hold the black handle).
 - **Use the [4000 Voltage/Temperature Chart](#)** to determine the correct Power Supply time setting.
 - **Heat the Insertion Tool** with the Power Supply to melt the adhesive.
 - **Use the correct grip** to unplug the assembly from the Power Supply (only hold the black handle).
 - **Let the seal cool for about 45 seconds** to allow adhesive to set before removing the External Magnet, Pressure Pads and Insertion Tool.
 - **Wiggle the Insertion Tool from side-to-side, then pull it out in a straight line.** Avoid bending the tool.
 - **Clean the Insertion Tool while warm.** Wipe both sides to remove any toner or adhesive residue.
 - **Perform the Air Pressure Test** to confirm the integrity of the seal.
10. **Seal the Access Areas**
 - Apply sealant (silicone) to both pin-holes (where the Pin Plates entered the hopper).
 - Apply sealant along the inner edge of both 3" [76mm] plastic clips.
 - Position one clip along the RIGHT side rail.
 - Position the other clip along the LEFT side rail.
 - After adding toner, seal the Fill-hole with the Fill-hole Cap [thick].

QUESTIONS? See Training Manual or contact: 617.625.2594 / provide@erols.com